

Date: Friday, 10/20/2006 11:10:14 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER	
Job Number	: 29090		Part Number	: D32861	
Estimate Number	: 10892		Drawing Number	: D3286 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 10/20/2006	S.O. No. : N/A	Drawing Revision	: A	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 11/15/2006	
Previous Run	: 27594		Qty:	350	
Written By	: <i>JK OCT 20</i>		Um:	Each	
Checked & Approved By	: <i>JK OCT 20</i>				
Comment	: Est A 04/07/14 New issue KJ/JLM Est Rev:B Now on Waterjet 06-06-16 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M304S11GA	304/316 .125 Sheet		
<b>Comment:</b> Qty.: 0.0786 sf(s)/Unit Total : 3.1458 sf(s) 304/316 .125 Sheet Batch: <i>M101463</i>				
2.0	WATER JET	FLOW WATER JET		
<b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D3286 Dwg Rev: <i>A</i> Prog Rev: <i>A</i>				
<i>JAD 06-10-22 36</i> 2-Deburr if necessary <i>SAD 06-10-26 36</i>				
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <i>JAD 06-10-22 36</i>				
4.0	QC8	SECOND CHECK		
<i>JAD 10-10-25 36</i>				
<b>Comment:</b> SECOND CHECK				
5.0	BRAKE NC	NC BRAKE		
<b>Comment:</b> NC BRAKE Form as per Dwg D3286 <i>SIB 06-11-06 36</i>				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/11/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 10/20/2006 11:10:14 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 29090

Part Number: D32861

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10/20/06

36

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: S7420

34

36

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/20/06

Job Completion



10/20/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

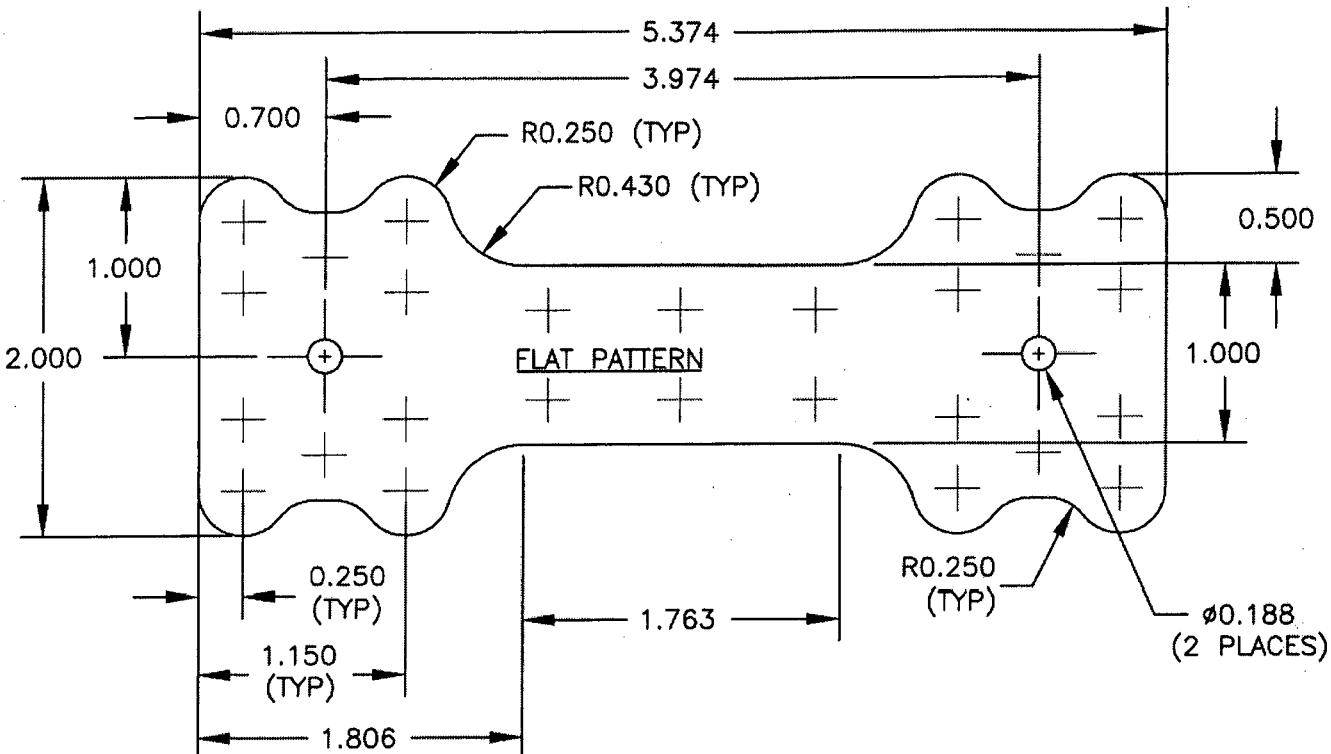
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

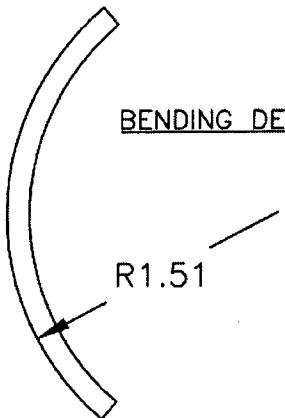
NOTE: Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3286
DATE		REV. A
04.05.06		SHEET 1 OF 2
		SCALE
		1:1
A	04.05.06	GROUND HANDLING PARTS
		NEW ISSUE



INDICATES LOCATION OF RIVET HOLES. SHOWN FOR REFERENCE ONLY, DO NOT DRILL.

BENDING DETAIL**RELEASED**  
04.06.06

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WITHOUT NOTICE  
WORK ORDER  
NO. 29090

**D3286-1 DOUBLER**

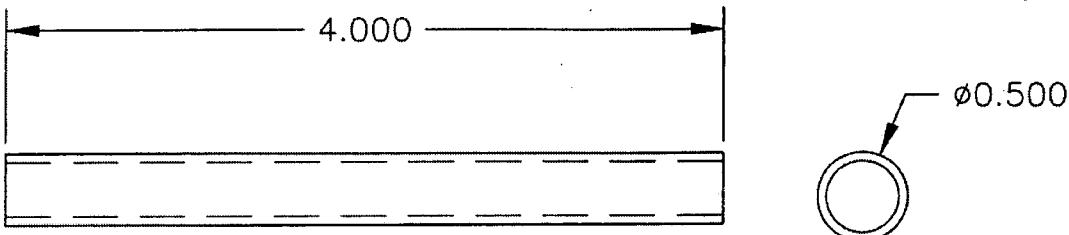
- 1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK  
(REF DART SPEC. M304S11GA)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3286 REV. A SHEET 2 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS SCALE 1:1



### D3286-3 SPACER

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL  
(REF DART SPEC. M304TR0.500W.049)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED  
04.06.22 *[Signature]*

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NO. *29090*

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DART AEROSPACE LTD	Work Order:	29090
Description: DOUBLER	Part Number:	D3286-1
Inspection Dwg:	Rev: A	Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## First Article      Prototype

Measured by:	SAN	Audited by:	J	Prototype Approval:	N/A
Date:	06:10:21	Date:	06.10.25	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	